



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3307-00
Job Sheet 189774



Part No: RBE350A93-3307-00

Job Qty: 2 pcs

Part Name: Tail Gearbox Seal Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/30/19

Job Tracking No:

Due Date: 2/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3307-00 Rev 2A IPP Rev A 18.01.24 New Issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	2/26/19		0.00	0.20	Small Fab - 1		DAS 71 9-89 19-4-23
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	2/26/19		0.00	0.00	QC 5 - 10		DAS 30 9-89 APR 23 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	2 pcs	2/26/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S174428



Part: RBE350A93-3307-00

Job No: 189774

Serial No/Batch: S174428

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 04/23/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	DAS 30 9-80 APR 24 2019
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS 21 9-80 APR 24 2019
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	2/26/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	

Part Op 100 - (Small Fab) 1-Assemble as per DWG. ***NOTE***see deviation attached.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location) Identify and Stock
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91253A540	Head Head Cap Screw	2 pcs (1 ea)	100-Small Fab - 1	S057169
RBE350A93-3307-00-01	Retractor	2 pcs (1 ea)	100-Small Fab - 1	S114073
RBE350A93-3307-00-03	Washer	2 pcs (1 ea)	100-Small Fab - 1	S076659
RBE350A93-3307-00-05	Hex Head Cap Screw	2 pcs (1 ea)	100-Small Fab - 1	S168988

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91253A540	2	22	0
	RBE350A93-3307-00-01	2	5	0
	RBE350A93-3307-00-03	2	2	0
	RBE350A93-3307-00-05	2	0	0

Part Specifications

Specifications could not be found.

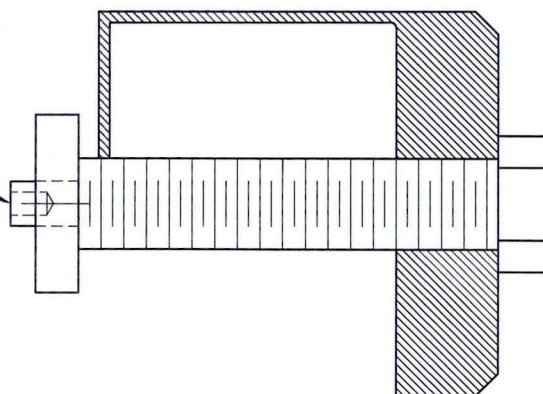
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS.	9/28/09	WP	DW
2	CH'D WASHER TO P/N -03 & S.F. TO 5, CH'D ALL THREAD TO HEX HEAD CAP SCREW P/N -05 & S.F. TO 3 PER D.W., DELETED -03 WELDMENT.	11/17/09	RJC	RW
2A	CORRECTED T/N WAS RBEA93-3307-00 IS RBE350A93-3307-00.	11/5/13	RJC	RW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189774

MCS
19-01-30

PRESS EXPAND UNTIL IT
RETAINS WASHER YET STILL
ALLOWS WASHER TO ROTATE.



ASSY QTY	ASSY #	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-01	1	RETRACTOR	4140 Q&T	Ø2-1/4 x 2-3/8	2
			-03	1	WASHER	1018	Ø1 x 3/8	3
		B/O	-05	1	HEX HEAD CAP SCREW	STEEL	1/2-20 UNF x 3 MCMASTER CARR #92620A750	4
	ASSY #							

RED BARN MACHINE	
TITLE TAIL GEARBOX SEAL EXTRACTOR	
DWG NO. RBE350A93-3307-00	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9/28/09
SHEET 1 of 4	

DRAWN BY: PERRITT
APPROVED <i>D Weil</i>
HEAT TREAT
FINISH SPEC
USED ON MODEL
EUROCOPTER AS350/355

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					